

C6636133

MODEL 700™ M24

Model **SMS**™

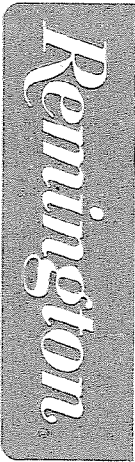
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

MODEL 700™ M24

UPONT
REG. U.S. PAT. & TM. OFF.

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6636133

ORDER NO.
5716

20

MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636133

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636133

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR 9 1991		K.R.
	Magnaflux Bolt	APR 9 1991		IC
615	Rollmark Caliber	APR 9 1991		GS
617	Drill and Tap Sight Holes	APR 19 1991		LB
618	Polish Barrel	APR 19 1991		CSB
620	Apply Coatings (Barrel Action)		5-10-91	TA
	Apply Coating (Bolt)			P
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	RL

op. #	BARBER - M24 0038107 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-28-91	DH
	G) Safety Off Force	4	4	3			5-28-91	DH
	H) Trigger Pull Test & Retainability						5/25/91	SH
	I) Firing Pin Indent	.020	.020	.020			5-28-91	DH
	J) Assemble Stock						5/28/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/28/91	RW
	M) Iron Sight Alignment						5/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	RW
	O) Attach Scope to Rifle						5/28/91	RW
	P) Detach & Attach Scope 20 Times						5/28/91	RW
640	Gallery Target & Test						5-30-91	DH
	A) Time						5-30-91	DH
	B) Malfunctions						5-30-91	DH
	C) Pierced Primers						5-30-91	DH
	D) Optical Clarity of Scope						5-30-91	DH
645	Inspect for Live Ammo						5-30-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.41	2.40	2.58	2.53	2.53	6/1/91	SH
	C) Function						6-1-91	DH
660	Pack						6-20-91	RW

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C.6636133DATE 5/25/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.64	2.48	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.51	2.40	
PULL #3	2.50	2.28	2.38	2.58	
PULL #4	2.50	2.33	2.38	2.53	
PULL #5	2.39	2.46	2.44	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.56		
PULL #2	3.52	3.38		
PULL #3	3.54	3.60		
PULL #4	3.51	3.50		
PULL #5	3.57	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.38		4.36
PULL #2	4.29	4.33		4.40
PULL #3	4.43	4.38		4.39
PULL #4	4.39	4.44		4.40
PULL #5	4.38	4.39		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636133
30 May 1991

CENTROIDAL DISTANCES

0 TO	1	.430785
1 TO	2	.647446
1 TO	3	.427404
1 TO	4	.201556
1 TO	5	.387743

$\frac{51^3}{2}$ (----) FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .069
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .309977
THE AMR FOR THIS RIFLE IS: 1.04

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636133

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.071

VS = 2.268

GS = 3.047

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.790	.688
MINIMUM X	-1.153	-.832	-.734
MAXIMUM Y	1.202	1.086	1.130
MINIMUM Y	-1.067	-1.182	-1.046
CENTROID X	.430	.558	.460
CENTROID Y	-.026	.090	-.046
POA TO CENTROID in.	.431	.566	.463
MIN RADIUS	.142	.278	.121
MEAN RADIUS	.929	.867	.780
MAX RADIUS	1.552	1.339	1.191
HORIZONTAL SPREAD	2.071	1.622	1.622
VERTICAL SPREAD	2.268	2.268	2.176
EXTREME SPREAD	3.047	2.310	2.193
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

30 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6636133

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 5

HS = 2.697

VS = 3.815

GS = 4.002

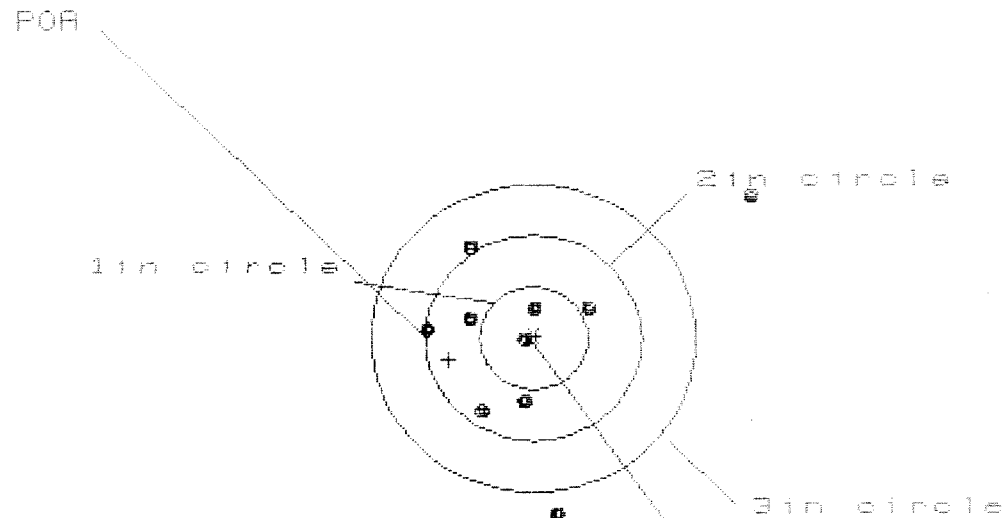
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	1.032	1.040
MINIMUM X	:	-1.647	-1.665	-1.536
MAXIMUM Y	:	2.177	.854	.679
MINIMUM Y	:	-1.638	-1.396	-1.437
CENTROID X	:	-.195	-.177	-.306
CENTROID Y	:	-.195	-.437	-.262
POA TO CENTROID in.	:	.275	.471	.403
MIN RADIUS	:	.133	.216	.263
MEAN RADIUS	:	1.194	1.091	1.005
MAX RADIUS	:	2.183	1.772	1.595
HORIZONTAL SPREAD	:	2.697	2.697	2.576
VERTICAL SPREAD	:	3.815	2.250	2.116
EXTREME SPREAD	:	4.002	3.358	2.699
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			5	

30 May 1991

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CENTERFIRE PATTERNS # 3

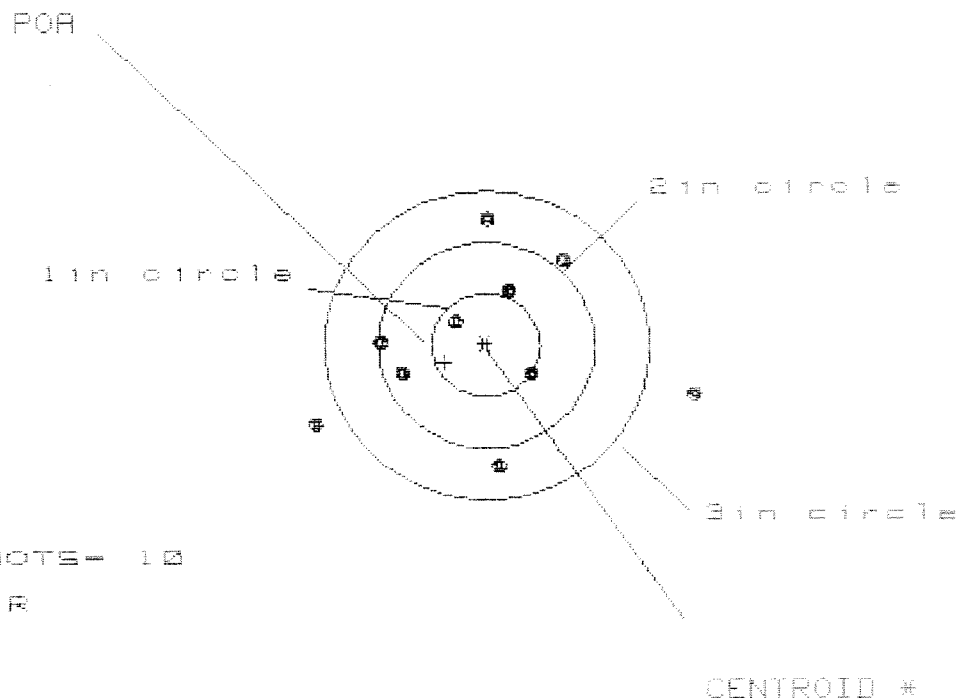


PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.814	.740	.797
MINIMUM X	-.972	-.749	-.692
MAXIMUM Y	1.369	.993	.795
MINIMUM Y	-1.743	-1.591	-.794
CENTROID X	.787	.564	.507
CENTROID Y	.209	.057	.255
POA TO CENTROID in.	.814	.566	.568
MIN RADIUS	.109	.218	.177
MEAN RADIUS	.933	.749	.604
MAX RADIUS	2.435	1.654	.848
HORIZONTAL SPREAD	2.986	1.489	1.489
VERTICAL SPREAD	3.112	2.584	1.589
EXTREME SPREAD	3.588	2.762	1.591
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636133

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HE= 3.537

VS= 2.387

GS= 3.554

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.964	.977	.807
MINIMUM X	:	-1.573	-1.355	-.944
MAXIMUM Y	:	1.219	1.170	1.065
MINIMUM Y	:	-1.168	-1.217	-1.322
CENTROID X	:	.383	.165	.334
CENTROID Y	:	.170	.219	.324
POA TO CENTROID in.	:	.419	.275	.466
MIN RADIUS	:	.382	.231	.248
MEAN RADIUS	:	1.060	.930	.828
MAX RADIUS	:	2.014	1.594	1.338
HORIZONTAL SPREAD	:	3.537	2.332	1.752
VERTICAL SPREAD	:	2.387	2.387	2.387
EXTREME SPREAD	:	3.554	2.829	2.389
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

30 May 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.694

VS= 2.989

GS= 4.157

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.551
MINIMUM X	-2.143
MAXIMUM Y	1.093
MINIMUM Y	-1.986
CENTROID X	.106
CENTROID Y	.187
POA TO CENTROID in.	.215
MIN RADIUS	.083
MEAN RADIUS	1.086
MAX RADIUS	2.579
HORIZONTAL SPREAD	3.694
VERTICAL SPREAD	2.989
EXTREME SPREAD	4.157
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	7